

Work Order ID 70244

Wednesday, June 01, 2011 3:30:49 PM



Page 1

Item ID: D4055-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MC*

Date: *1-06-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

Weld per dwg A/R Aluminum rod Batch: *114703* 0.00
117884



Large Fab

Large Fab

Memo

0.00

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

11-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D4055-041

Accept

Revision ID:

Item Name: Fuel Tank Assembly

Start Date: 6/1/2011 Start Qty: 1.00

Required Date: 6/29/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/07/13

121

Weld per dwg A/R Aluminum rod Batch: ~~11117884~~ 0.00

Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

BE11-07-14

1 0

122

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 0 BE11/07/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID:	D4055-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Fuel Tank Assembly				Stop	
Start Date:	6/1/2011	Start Qty:	1.00			
Required Date:	6/29/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123 	QC5- Inspect part completeness to step on W/O	0.00				1			
QC Quality Control	Memo ***Pressure Test as per dwg D4055*** Pressure tested to 3psi submerged AND with soap/water	0.00		11/07/14 m m 11-07-18					
130 	Chemical Conversion Coat per QSI005 4.1	0.00				1	6	211	11-07-18
HandFinish Hand Finishing	Memo ✓ brush alodine on tank. No alodine inside	0.00							
140 	QC3- Inspect Part Finish	0.00				1	6	BR	11-7-18.
QC Quality Control	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D4055-041

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Setup Start

Revision ID:

Stop

Item Name: Fuel Tank Assembly

Start Date: 6/1/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M117338.

Memo

0.00

Powder Coating

Mask prior to powdercoat

Start Time: 1:20

Oven Temperature: 300

Finish Time: 1:50.

1 0 BL 11-7-18.

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 M 11/7/19

185

0.00



SprayPaint

Memo

M111644

0.00

Spray Painting

Seal inside of tank using Sloshing Sealer as per dwg

1 0 M 11/7/19

W/O:		WORK ORDER CHANGES					
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Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190



Small Fab

Memo

0.00

0.00

Small Fab

Assemble as per dwg

454/07/22 (1)

200



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

11 07 22 (1)

220



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

N/A 11.07.22

W/O:		WORK ORDER CHANGES					
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Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 70244

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verified by:DD IPP Rev D: 11.06.01 per D4055
revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 Placard		Manufactured	No			190	Each	4.0000	1	1			
<div>Location</div> <div>ST104</div> <div>68930</div> <div>Loc Qty</div> <div>4</div> <div>4</div> <div>Loc Code</div>													
D3997-5 Placard		Manufactured	No			190	Each	5.0000	2	2			
<div>Location</div> <div>ST104</div> <div>65436</div> <div>Loc Qty</div> <div>5</div> <div>5</div> <div>Loc Code</div>													
D3997-11 Placard		Manufactured	No			190	Each	9.0000	1	1			
<div>Location</div> <div>ST104</div> <div>65124</div> <div>Loc Qty</div> <div>9</div> <div>9</div> <div>Loc Code</div>													
D3997-17 Placard		Manufactured	No			190	Each	9.0000	1	1			
<div>Location</div> <div>ST104</div> <div>55410</div> <div>65125</div> <div>Loc Qty</div> <div>9</div> <div>1</div> <div>8</div> <div>Loc Code</div>													

6/5/11/07/22

6/5/11/07/22
B71170(2)

6/5/11/07/22

6/5/11/07/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70244

Parent Item: D4055-041


Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011


Required Date: 6/29/2011

Start Qty: 1.00


Required Qty: 1.00

✓ D3999-041 Manufactured No 100 Each 2.0000 1 1  11.07.12
Baffle Assembly, Aft


Location Loc Qty Loc Code
WA014 370248 2
65437 2

✓ D3999-043 Manufactured No 100 Each 2.0000 1 1  11.07.12
Baffle Assembly, Fwd


Location Loc Qty Loc Code
WA014 370249 2
65439 2

✓ D4000-1 Manufactured No 100 Each 5.0000 1 1  11.06.21
Fuel Supply Fitting

Location Loc Qty Loc Code
WA013 5
65716 5

✓ D4000-5 Manufactured No 100 Each 3.0000 1 1  11.06.21
Fuel Tank Vent Fitting

Location Loc Qty Loc Code
WA013 3
65444 3

✓ D4000-9 Manufactured No 100 Each 5.0000 3 3  11.07.12
Grommet

Location Loc Qty Loc Code
WA013 370250 5
65109 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Work Order ID: 70244

Parent Item: D4055-041


Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00


Required Qty: 1.00

✓ D4000-043 Manufactured No 100 Each 1.0000 1 1

 Drain Fitting Assembly, Fwd

Location B70963 Loc Qty Loc Code

WA013 B70964 1


65442 1

✓ D4000-045 Manufactured No 100 Each 2.0000 1 1

 Fuel Pickup Fitting Assembly

Location Loc Qty Loc Code

WA013 B70810 2


68385 2

✓ D4000-041 Manufactured No 100 Each 2.0000 1 1

 Drain Fitting Assembly, Aft

Location Loc Qty Loc Code

WA013 B70968 2


69096 2

✓ D4001-1 Manufactured No 100 Each 4.0000 1 1

 Fitting

Location Loc Qty Loc Code

WA013 66840 4

4

✓ D4008-11 Manufactured No 100 Each 4.0000 1 1

 Hinge Half

Location Loc Qty Loc Code

ST108 B65445 4

67650 4

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 70244

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

D4008-041 Manufactured No

190 Each 0.0000

1

1



Fuel Filler Splash Guard Assembly

D4023-3 Manufactured No

100 Each 0.0000

1

1



Cap and Flange

D4025-1 Manufactured No

100 Each 2.0000

1

1



Fuel Quantity Sender

Location

Loc Qty

Loc Code

ST241A

2

65131

2

D4055-11 Manufactured No

100 Each 5.0000

1

1



Tank Front and Bottom

Location

Loc Qty

Loc Code

WA013

5

65447

2

68500

3

D4055-9 Manufactured No

100 Each 6.0000

1

1



Tank Back

Location

Loc Qty

Loc Code

WA013

6

63948

1

65451

2

66842

3

B59517

6/11/07/22

11.07.11 B70204

6/11/07/22

B69502 (1x)

11.07.11

1

11.07.12

1

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 70244



Parent Item: D4055-041



Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4055-7

 Tank Fwd End

Manufactured No

100

Each

2.0000

1

1



11-07-13

Location

Loc Qty

Loc Code

WA014

370251

2

65450

2

✓ D4055-5

 Tank Upper Cut Out

Manufactured No

100

Each

6.0000

1

1



11-07-13

Location

Loc Qty

Loc Code

ST119

2

65449

2

WA013

4

67737

4

✓ D4055-3

 Tank Aft End

Manufactured No

100

Each

4.0000

1

1



11-06-21

Location

Loc Qty

Loc Code

WA

2

68501

2

WA014

2

65448

2

✓ D4055-1

 Tank Top

Manufactured No

100

Each

4.0000

1

1



11-06-21

Location

Loc Qty

Loc Code

WA

2

68502

2

WA013

2

65446

2

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Work Order ID: 70244

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

D4057-1 Manufactured No

100

Each

17.0000

3

3



Retaining Ring



11.07.12

Location

Loc Qty

Loc Code

WA013

17

55826

17

3

AN3H5A

Purchased

No

190

Each

22.0000

5

5



Bolt



11/02/12

Location

Loc Qty

Loc Code

ST350

22

114941

2

116704

20

5

NAS1149D0363J

Purchased

No

190

Each

2,432.000

5

5



Washer



11/07/12

Location

Loc Qty

Loc Code

ST298

2432

116583

432

117291

1000

117505

500

117601

500

5

D4404-1

Manufactured

No

190

Each

0.0000

1

1



Cushion



B70247 (1a)

11/07/12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

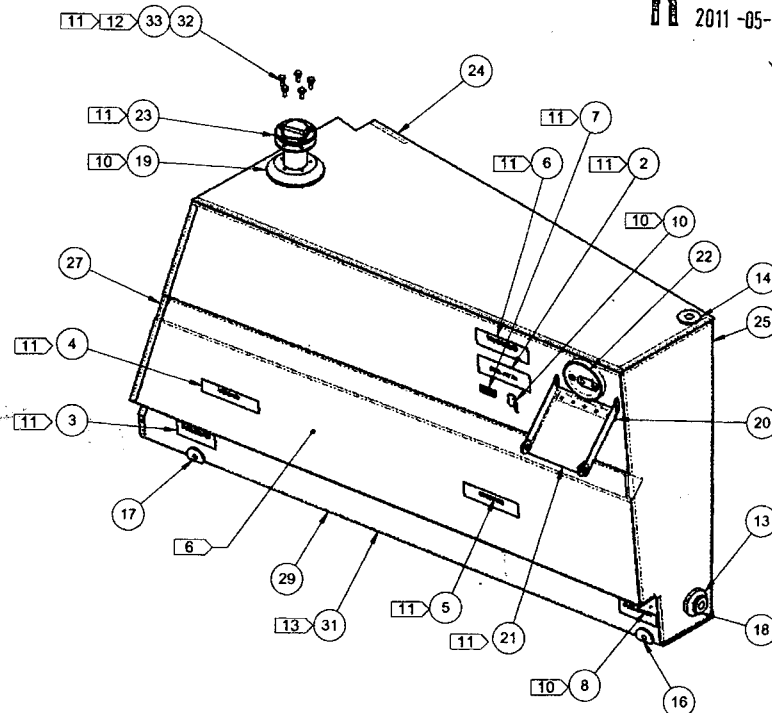
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY

B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	11.05.12
A	NEW ISSUE	HS 10.04.16
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.05.12	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B
TITLE TANK	SHEET 1 OF 15
SCALE	NTS

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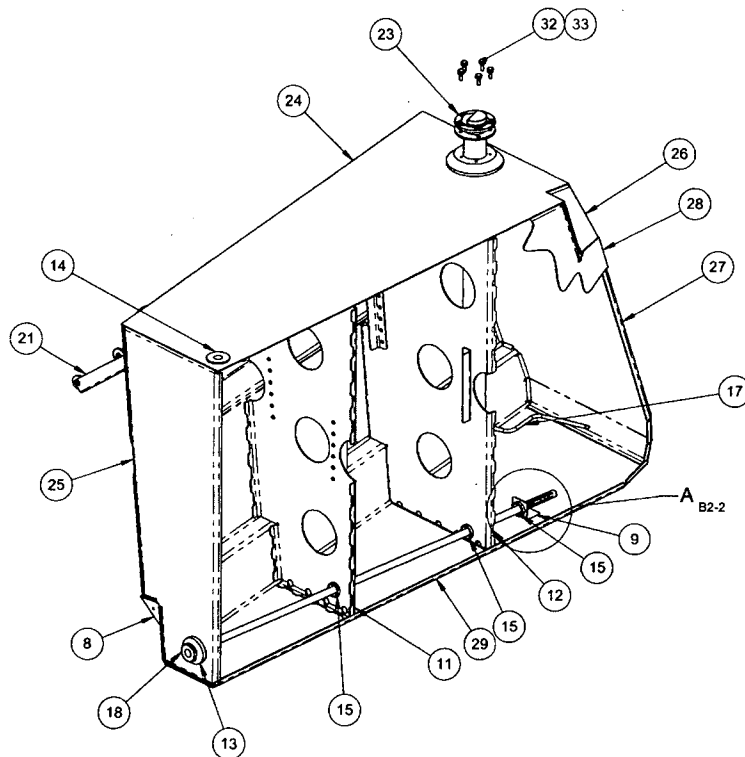
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

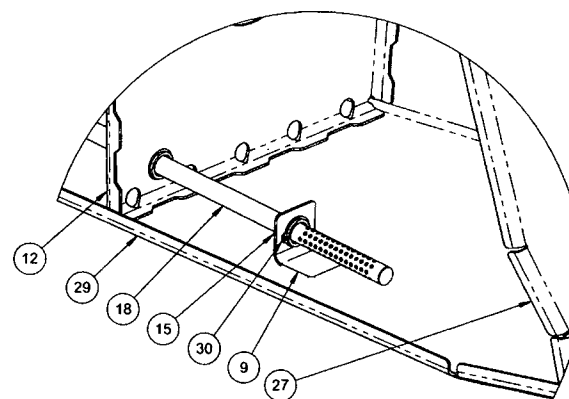
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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 2011-05-30
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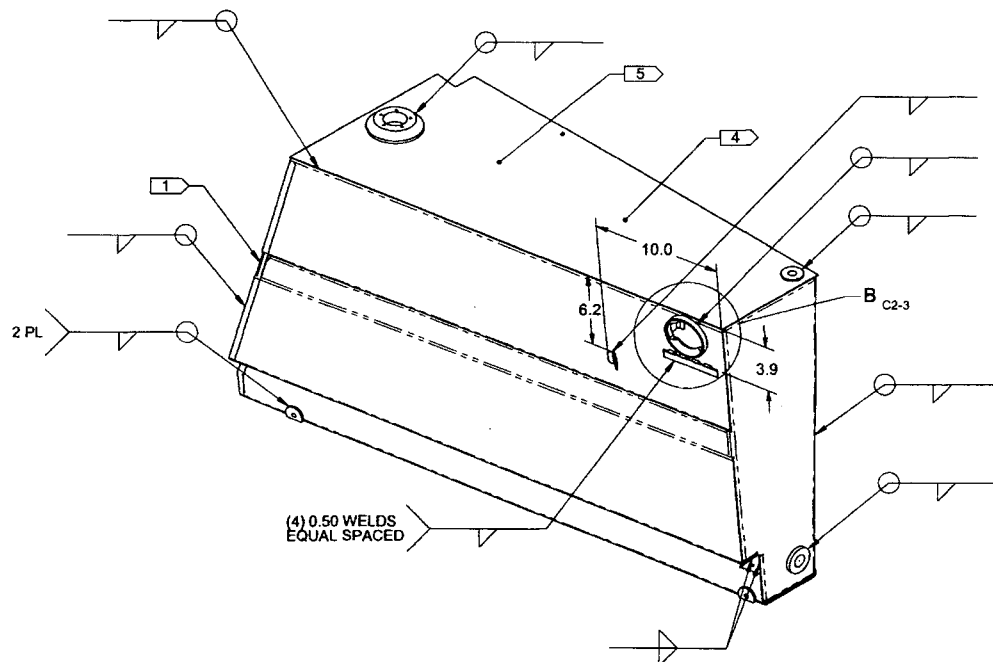
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

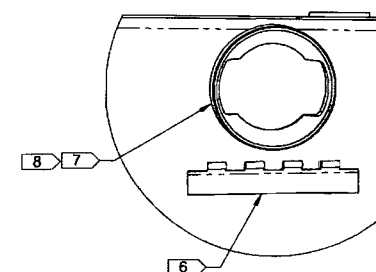
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**



**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**

C4-3

RELEASED
2011-05-30
M

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\phi 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

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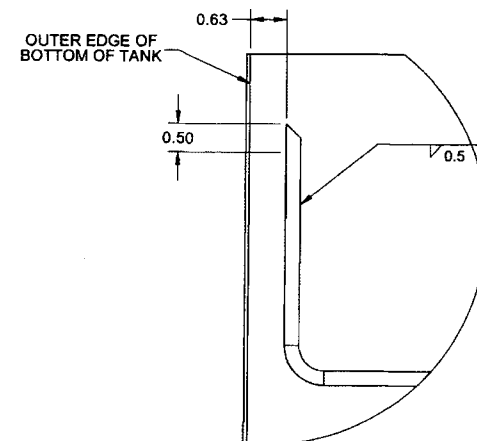
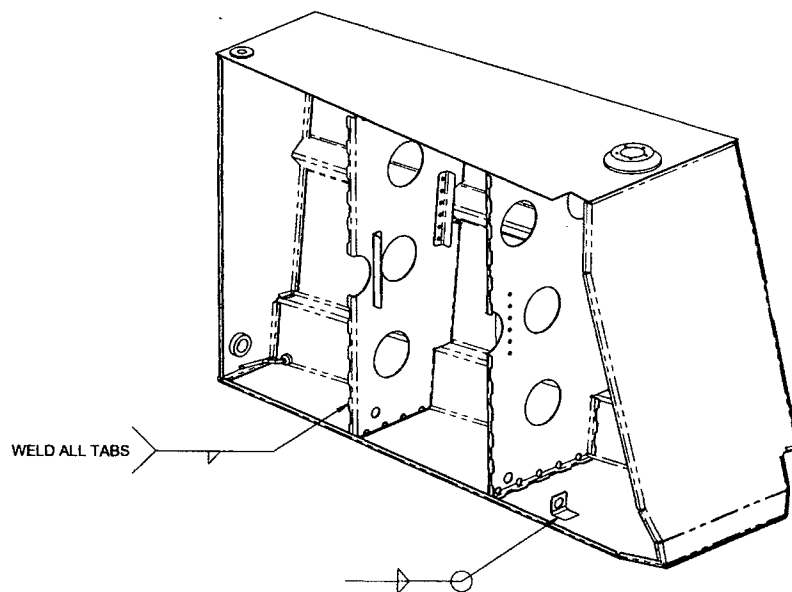
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DRAIN TUBE INSTALLATION - TYP
VIED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

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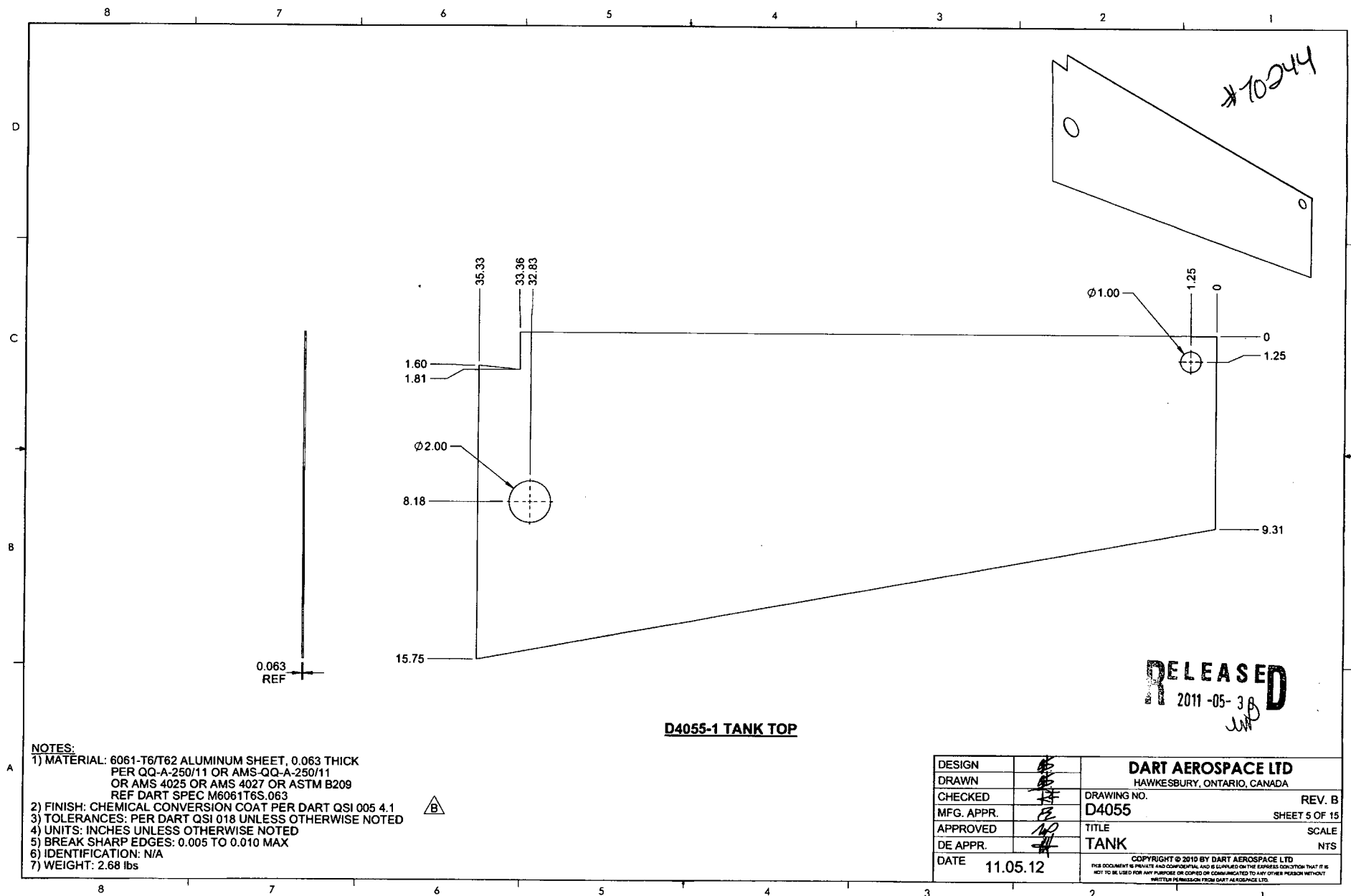
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs



D4055-1 TANK TOP

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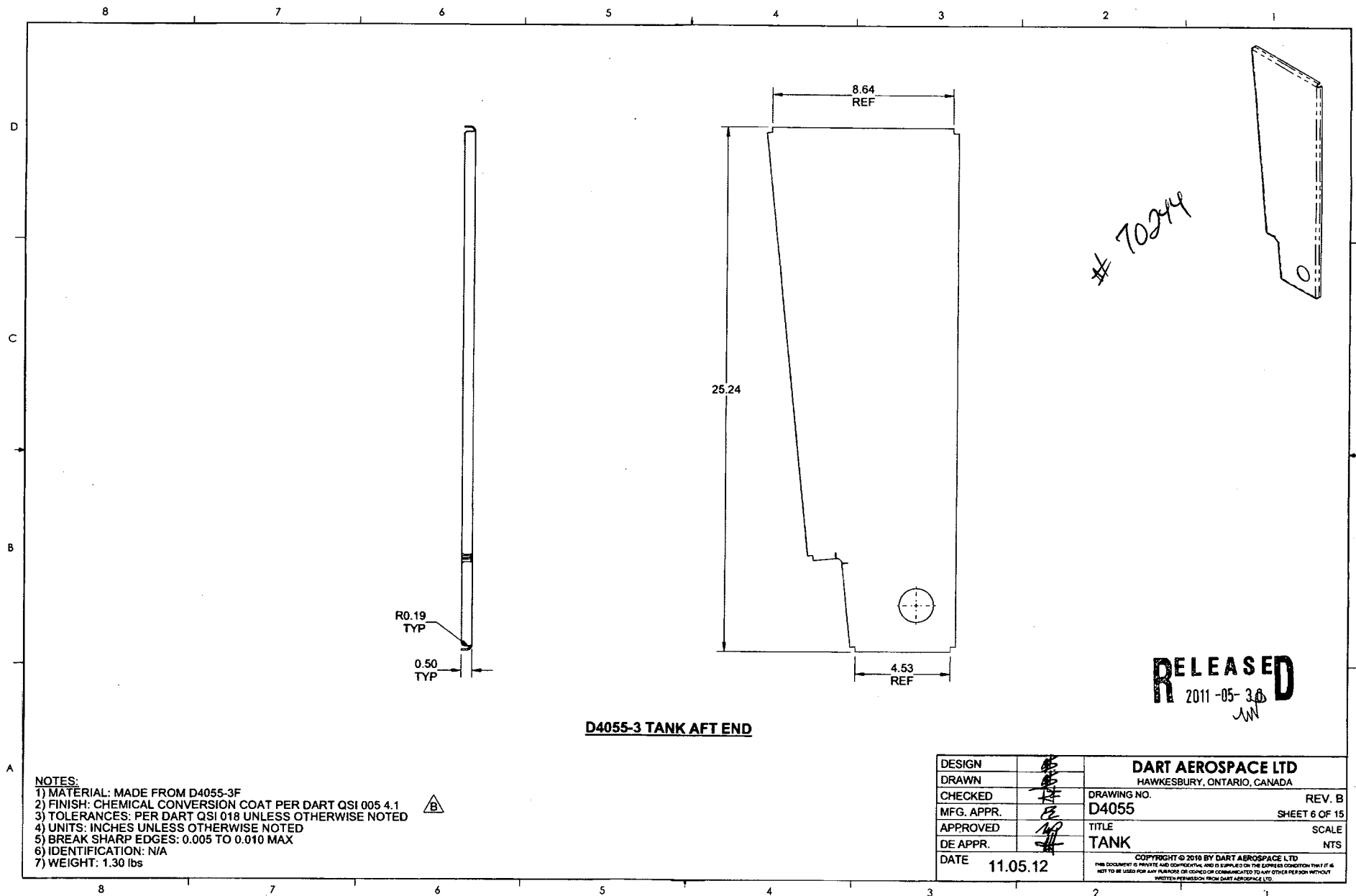
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



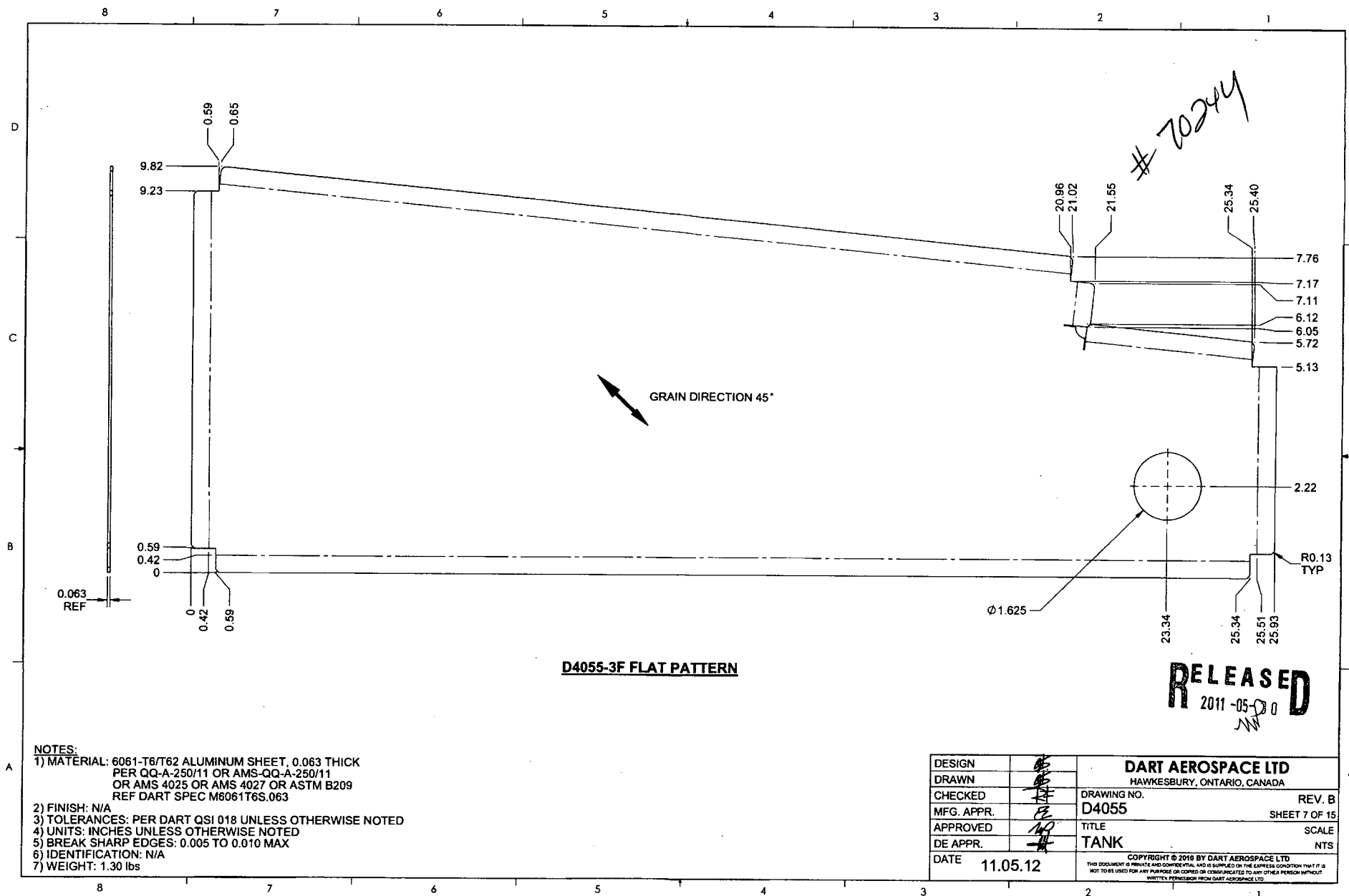
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



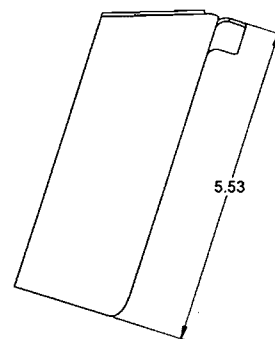
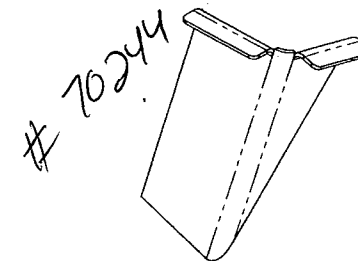
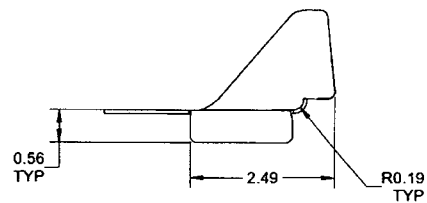
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
NN

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-5F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs



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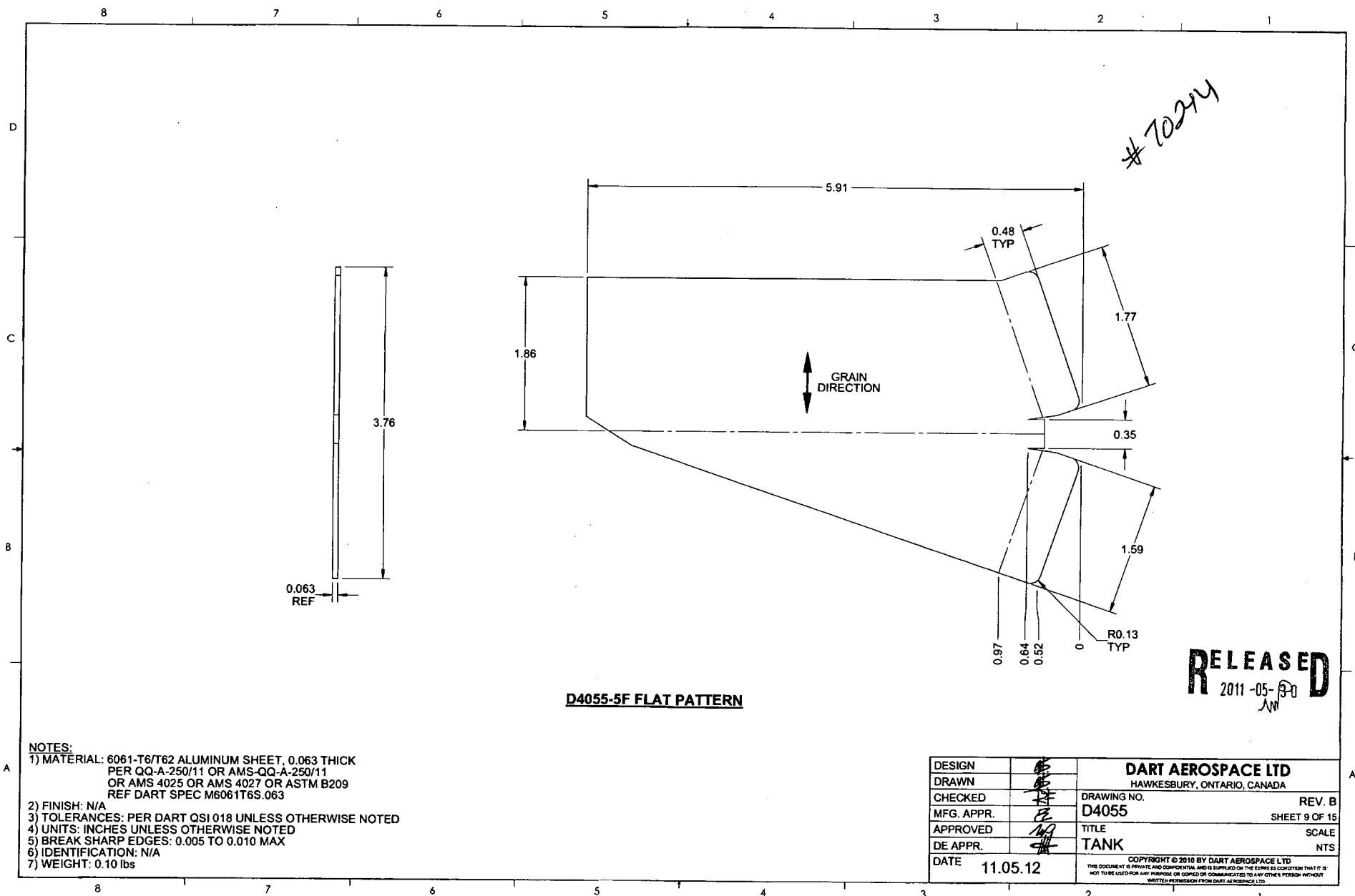
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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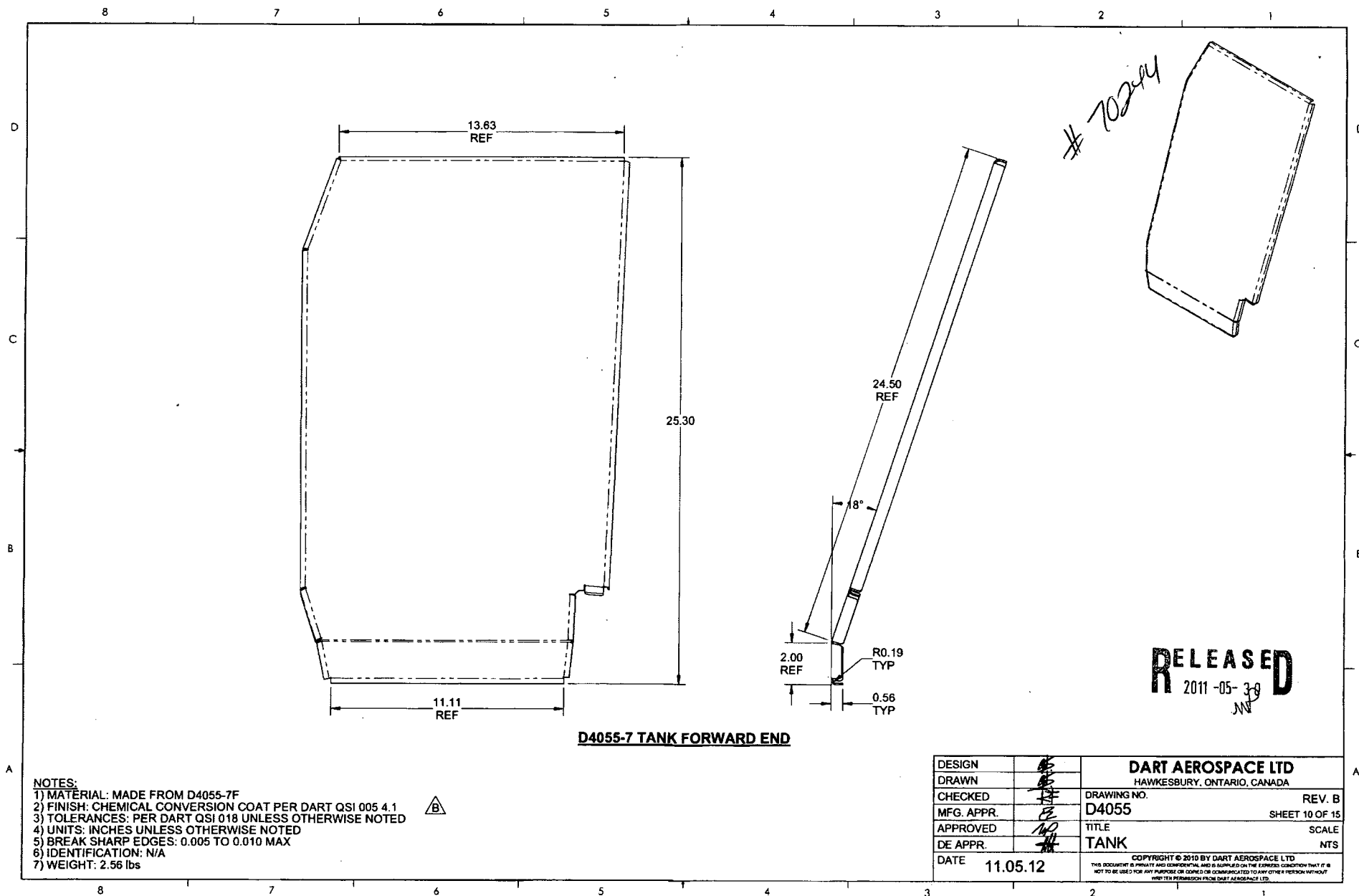
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

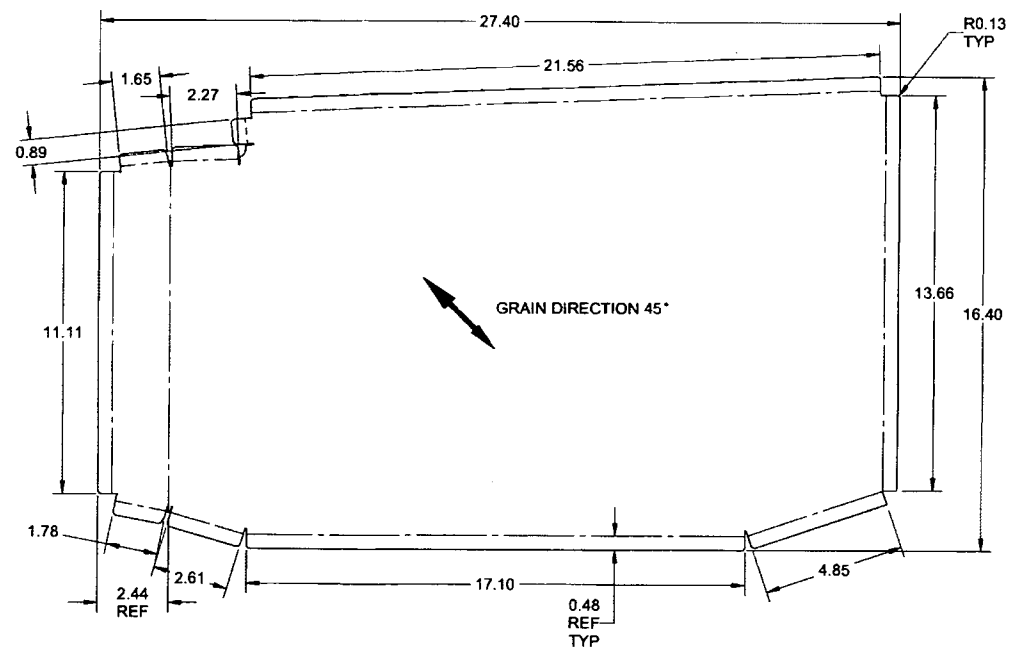
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

* 70244

0.063
REF



D4055-7F FLAT PATTERN

RELEASED
2011-05-30
NW

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

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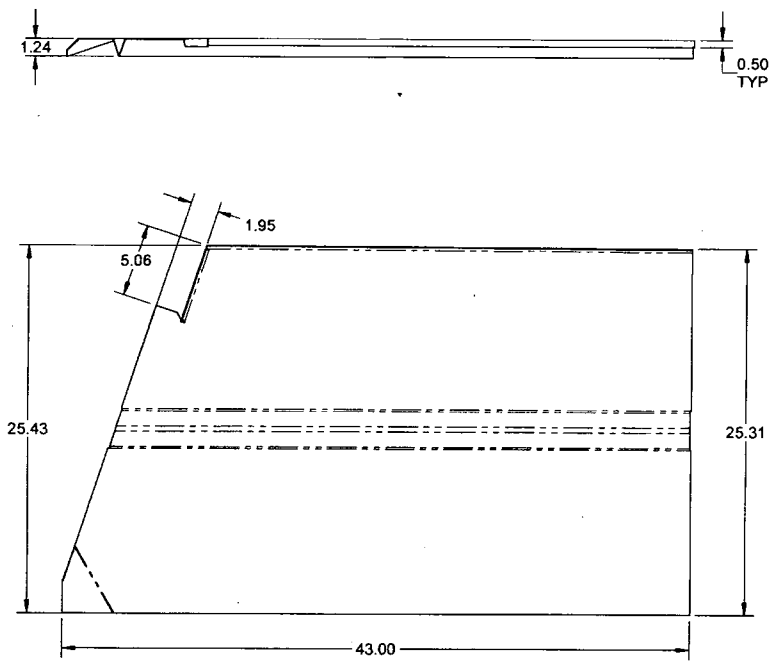
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-9 TANK BACK

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



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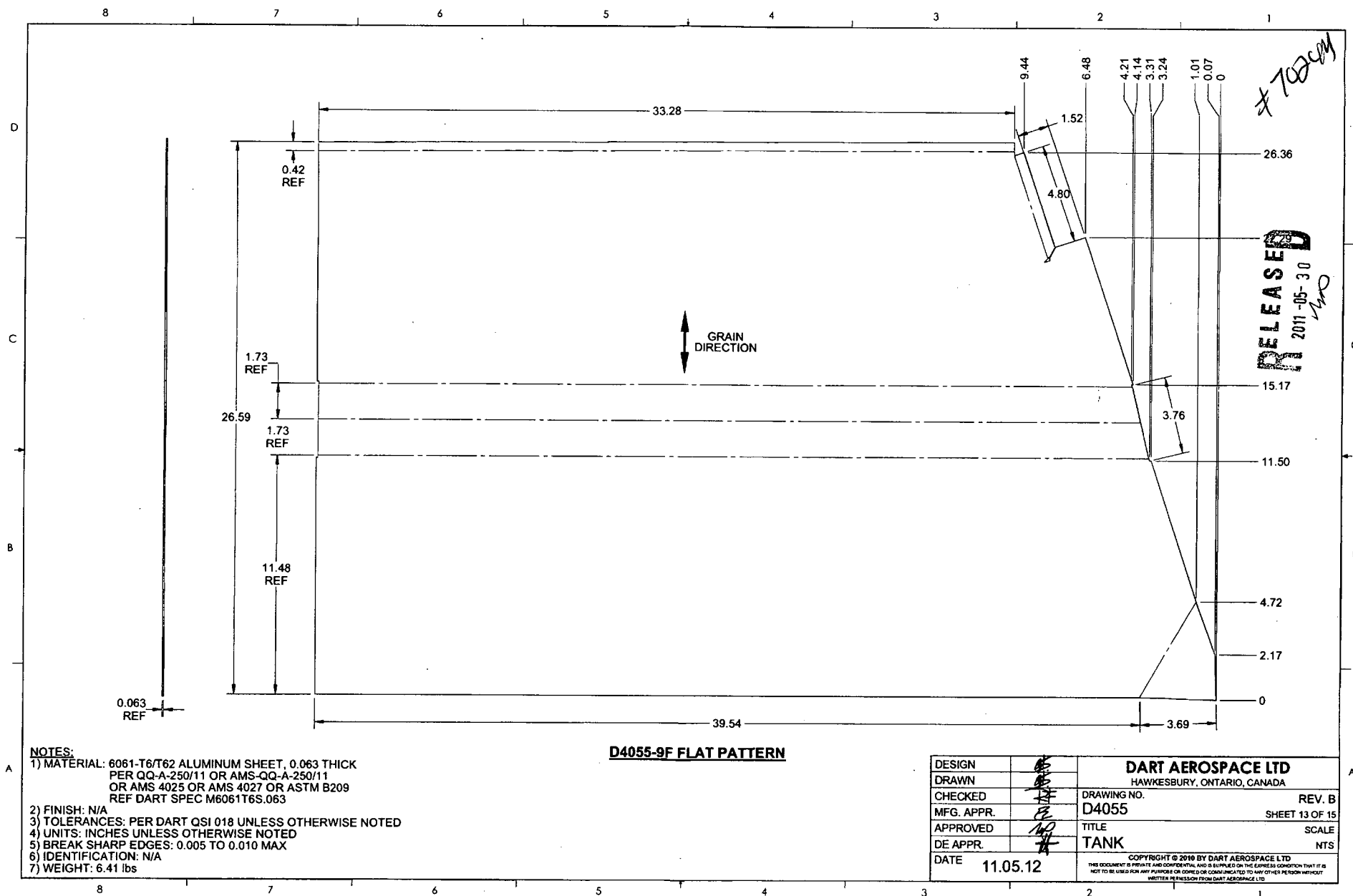
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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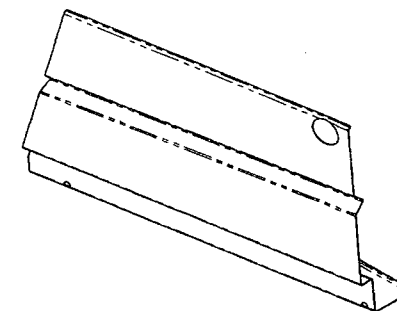
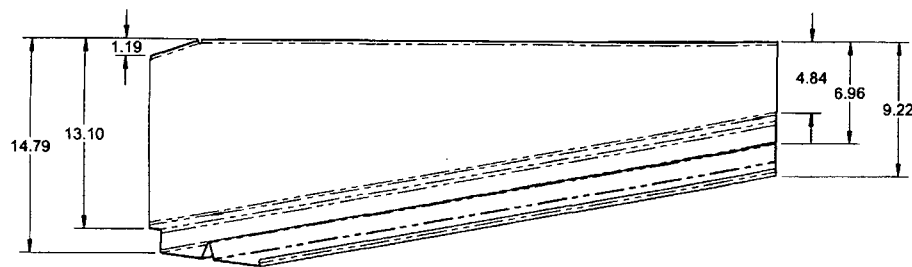
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

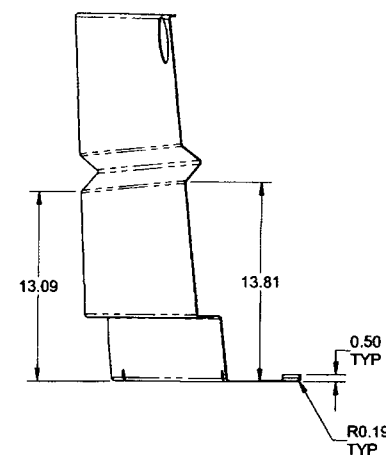
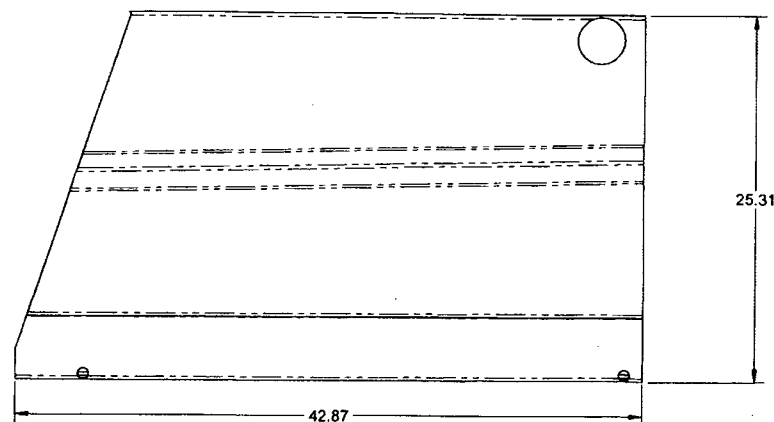
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#70244



D4055-11 TANK FRONT AND BOTTOM

NOTES:

- 1) MATERIAL: MADE FROM D4055-11F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs



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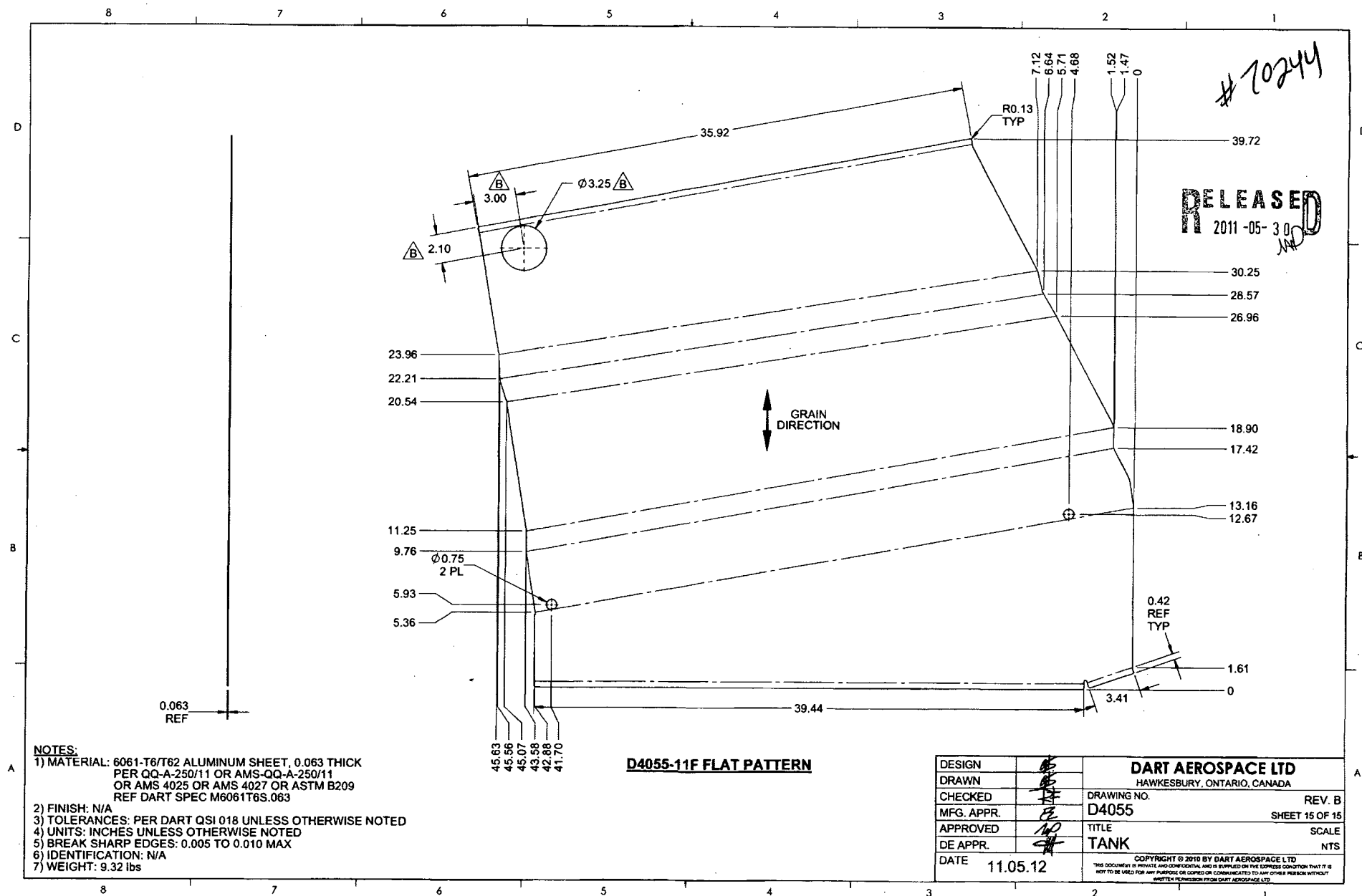
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NOTE: Date & initial all entries



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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries